DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 70.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-007484
Date Inspected: 01-Jul-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Japan Steel Works

OSM Arrival Time: 1300
OSM Departure Time: 2130
Location: Muroran, Japan

CWI Name: Pin-Tang Hsu

Inspected CWI report:	☐	Yes	☑	No	☐	N/A
Electrode to specification:	☑	Yes	☐	No	☐	N/A
Qualified Welders:	☑	Yes	☐	No	☐	N/A
Approved Drawings:	☑	Yes	☐	No	☐	N/A

CWI Present:	☑	Yes	☐	No		
Rod Oven in Use:	☑	Yes	☐	No	☐	N/A
Weld Procedures Followed:	☑	Yes	☐	No	☐	N/A
Verified Joint Fit-up:	☑	Yes	☐	No	☐	N/A
Approved WPS:	☑	Yes	☐	No	☐	N/A
Delayed / Cancelled:	☐	Yes	☑	No	☐	N/A

Bridge No: 34-0006
Component: Tower, Jacking and Deviation Saddles

Summary of Items Observed:

On this date, 7/01/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in Foundry and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2E3 - Assembled Deviation saddle has been located in Machine Shop 2 awaiting final machining.
W2W1 - Per Mr. H.Kon of JSW staff, this assembled saddle section is to begin MT inspection, in Fabrication Shop #4 by QC NIS personnel. This NDE Hold point follows Post Weld Heat Treat (PWHT) sequence.
W2W2 - QA Inspector observed four welders being monitored by QC (CWI's Chung Fu Kuan and Pin-Tang Hsu), M.Kato 08-5018, T.Watanabe 08-5169, M.Inoue 92-5683 (who was later relieved by M.Matudate 08-5151), J.Yaegashi 07-2941, welding joints W2Y-8U, W2Y-7U, W2Y-17U-1 and W2Y-17U-2 respectively. Their process and procedure was FCAW, weld wire 1.6mm TM95, and SJ3011-7. M.Kato 08-5018, began welding joint W2Y-6U (upon finishing W2Y-8U) until the end of this QA Inspector's shift.

TOWER SADDLES

T1-2 - Welder Y.Watanabe 73-3873 was actively welding repairs to CJP joints 8Y-5L-3 and -4 (but was later replaced by T.Sudo 03-3082), and Mr. Kobayashi 73-3873 was welding 8Y-5L-4 FCAW process with 1.6mm TM55 weld wire. Parameters were monitored on a random basis by QC CWI Mr. Chung Fu Kuan and later by

CWI Mr. Pin-Tang Hsu.

T1-3 - JSW personnel actively grinding base plate at areas identified for fit up of saddle plate portion. These actions take place in Fabrication Shop #4.

EAST SADDLES

E2E1 - Cast section awaits JSW to commence the approved repair to major and minor excavations per ECS (as it sits in the Foundry). End Splay Cover plate fixture is in process of PWHT NDE by QC NIS personnel. UT being performed by M.Sato #81 and MT by R.Kumagai #132 of Nikko Inspection Services.

E2W1 - Casting has had weld repair reinforcements carbon arc'd followed by mechanical grinding and now awaits blast cleaning to prepare repairs for NDE, in Foundry.

West Jacking Saddle - Cast Section is being ground by hand held power grinders by one individual to further shape the texture left by Carbon Arc process in the Foundry.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer